Work Order ID 48603

October 7, 2009 1:04:56 PM

Item ID: D350-748-241TRN **Accept** **Setup Start** **Stop**

Revision ID: D

Item Name: Crosstube Turning Detail

Start Date: 7/15/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/03/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** CY **Date:** 09/10/07 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D350-748-241	Rev D

100 0.00

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

Memo 0.00

1-Fill tube with sand & install plugs on both ends as per Folio FA647□2-Turn first side as per Folio FA647□3- File transition lines smooth.

O.M 09-05-17 ✓

110 QC1- Inspect dimensions to dimension sheet 0.00

QC

Quality Control

Memo 0.00

O.M 09-06-17 ✓

120 0.00

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

Memo 0.00

1-Turn second side as per Folio FA647□2- File transition lines smooth.□3- Scribe part # as per Dwg D350-748-241

O.M 09-06-17 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 48603

October 7, 2009 1:04:56 PM

Item ID: D350-748-241TRN **Accept** **Setup Start**

Revision ID: D **Stop**

Item Name: Crosstube Turning Detail

Start Date: 7/15/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/03/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC1- Inspect dimensions to dimension sheet	0.00							
QC	**Memo**	0.00				O.K	09-06	-17	Ⓞ
Quality Control									
140	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00				1	Ø	-	AWM 9-6-17
Quality Control									
150		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00				1	Ø	-	AWM 9-6-17
Large Fab	Grind machining marks.								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 48603

October 7, 2009 1:04:56 PM

Item ID: D350-748-241TRN **Accept** **Setup Start** **Stop**

Revision ID: D

Item Name: Crosstube Turning Detail

Start Date: 7/15/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/03/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Outsource process - Heat Treat	0.00							
Outsource1	**Memo**	0.00							
Outsource process - Heat Treat	Issue P/O: 10539 ☐Heat Treat to min 180 KSI As per Dwg D350-748-241☐Sand Blast tube after Heat Treat☐Possibe Supplier: Vac Aero☐Ensure Certificate of Conformity is attached								
170	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformaty is attached								
180	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control									

09-10-7

8/14/09

=> 8/14/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 48603

October 7, 2009 1:04:56 PM

Item ID: D350-748-241TRN **Accept** **Setup Start** **Stop**

Revision ID: D

Item Name: Crosstube Turning Detail

Start Date: 7/15/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/03/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00							
Packaging	Identify and stock in kanban rack☐Location: X-tube cel mB 09-11-23								
200	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

09/11/24

MF 09-11-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

October 7, 2009 1:04:56 PM

Work Order ID: 48603

Parent Item: D350-748-241TRNRevD

Parent Item Name: Crosstube Turning Detail

Start Date: 7/15/09 **Required Date:** 8/03/09

Comments:

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6018-125RevA		Manufactured	No			120	Each	58.0000	1.0000			

Crosstube Material

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
LG	58		_____
27472	6		_____
32913	52		_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 16/06/2009 8:48:54 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: X-TUBE AS 350/355 HI AFT
Job Number	: 48603		
Estimate Number	: 13225		
P.O. Number	:	**Part Number**	: D350748241TRN
This Issue	: 16/06/2009 **S.O. No.** :	**Drawing Number**	: D350-748-241 REV.D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : CROSSTUBES	**Drawing Revision**	: D
Previous Run	: 47172	**Material**	:
Written By	:	**Due Date**	: 23/06/2009 **Qty:** 1 **Um:** Each
Checked & Approved By	: JLD09.06.16		

Comment : Est Rev:A New Issue 08-03-06 DD verified by:ec
Est Rev B Removed polish 08.04.02 EC verified by : DD
Est Rev C Removed LPS-3 08.06.23 Ec verified by: DD

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0 ✓	D6018125	Crosstube Material

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Crosstube Material
D6018-125
2.299" OD X 2.000" ID
Batch: B32913 A.M 09.06.17

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3- File transition lines smooth. A.M 09.06.17

3.0	QC1	INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET A.M 09.06.17

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2- File transition lines smooth.

A.M 09.06.17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 16/06/2009 8:48:54 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** X-TUBE AS 350/355 HI AFT

Job Number: 48603 **Part Number:** D350748241TRN

Job Number:

Seq. #:	Machine Or Operation:	Description :
	3-Scribe part # as per Dwg D350-748-241	A.M 09.06.17
5.0	QC1	INSPECT ALL DIM TO DIM SHEET
	Comment: INSPECT ALL DIM TO DIM SHEET	A.M 09.06.17
6.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	AVM 9-6-17 (1)
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 Grind machining marks.	AVM 9-6-17 (1)
8.0 ✓	OUTSIDE SERV.11	OUTSIDE SERVICE -CROSSTUBES
	Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: _____ Heat Treat to min 180 KSI As per Dwg D350-748-241 Sand Blast tube after Heat Treat Possibe Supplier: Vac Aero Ensure Certificate of Conformity is attached	
9.0 ✓	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformaty is attached	
10.0 ✓	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	
11.0 ✓	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and stock in kanban rack Location:_____	

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 16/06/2009 8:48:54 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** X-TUBE AS 350/355 HI AFT

Job Number: 48603 **Part Number:** D350748241TRN

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48603
Description: Crosstube Assembly (AS350/355 High Aft)	Part Number:	D350-748-241
Inspection Dwg: D350-748-241 **Rev:** D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.208	+0.005/-0.000	2.212	✓			
	2.234	+0.005/-0.000	2.239	✓			
	2.253	+0.005/-0.000	2.254	✓			
	2.272	+0.005/-0.000	2.275	✓			
	2.299	+0.005/-0.000	2.303	✓			
	0.063	+/-0.010	0.063	✓			
	4.26	+/-0.030	4.260	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.50	+/-0.030	R0.500	✓			
SIDE B	2.240	+0.005/-0.000	2.245	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.208	+0.005/-0.000	2.212	✓			
	2.234	+0.005/-0.000	2.239	✓			
	2.253	+0.005/-0.000	2.254	✓			
	2.272	+0.005/-0.000	2.275	✓			
	2.299	+0.005/-0.000	2.304	✓			
	0.063	+/-0.010	0.063	✓			
	4.26	+/-0.030	4.260	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.50	+/-0.030	R0.500	✓			
	122.70	+/-0.060	122.740	✓			

Measured by:	AM	Audited by:	AWM	Prototype Approval:	N/A
Date:	09.06.17	Date:	9-6-17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D350-748-241 REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE NTS

A	06.03.31	NEW ISSUE
B	06.06.30	ADD D6018-125 & PRIME AND PAINT
C	06.08.14	ADD CAD PLATING
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.

RELEASED
06.10.31

QTY	P/N	DESCRIPTION
X	**D350-748-241**	**CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)**
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

UNDER REVIEW
09.02.05
PER DCR #09-001

OK
09.11.24

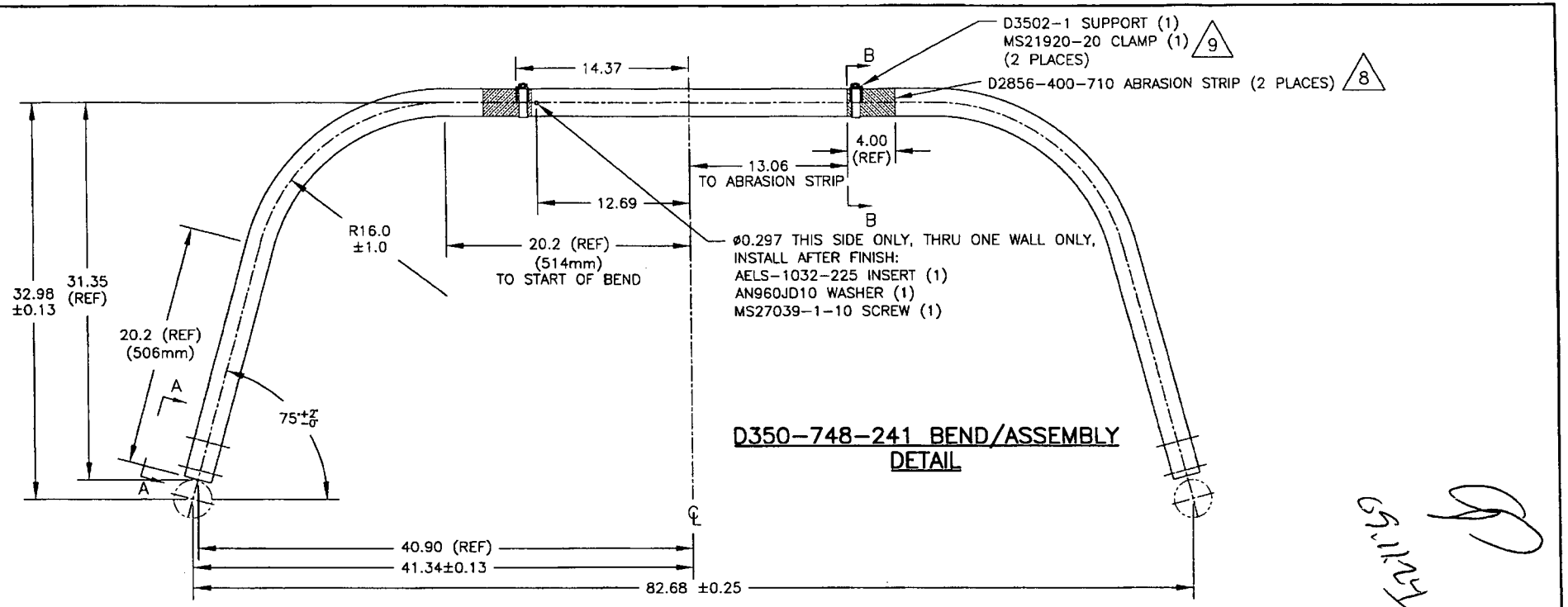
D350-748-141 CROSSTUBE:

1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
 FINISHED LENGTH = 122.70±0.06
2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
 CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
11) ALL DIMENSIONS ARE IN INCHES
12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

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SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 48603

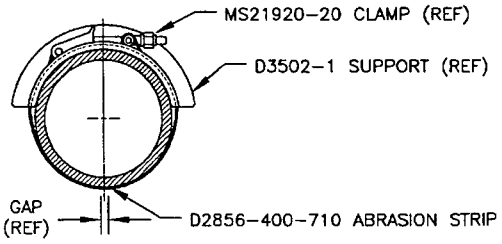
UNDER REVIEW
07.02.16
OK 07.11.22

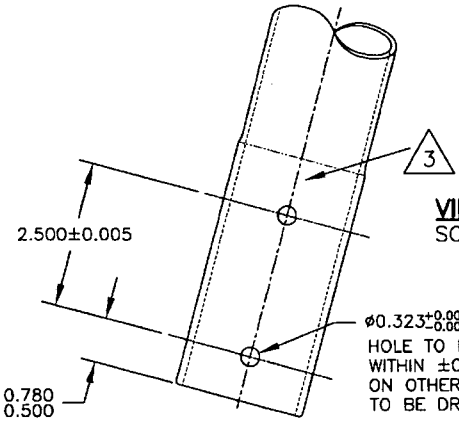
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D350-748-241 BEND/ASSEMBLY DETAIL

SECTION B-B
SCALE 1:2





VIEW A-A
SCALE 1:2

UNDER REVIEW
09.02.05

UNDER REVIEW
07.02.16
OK 07.10.22

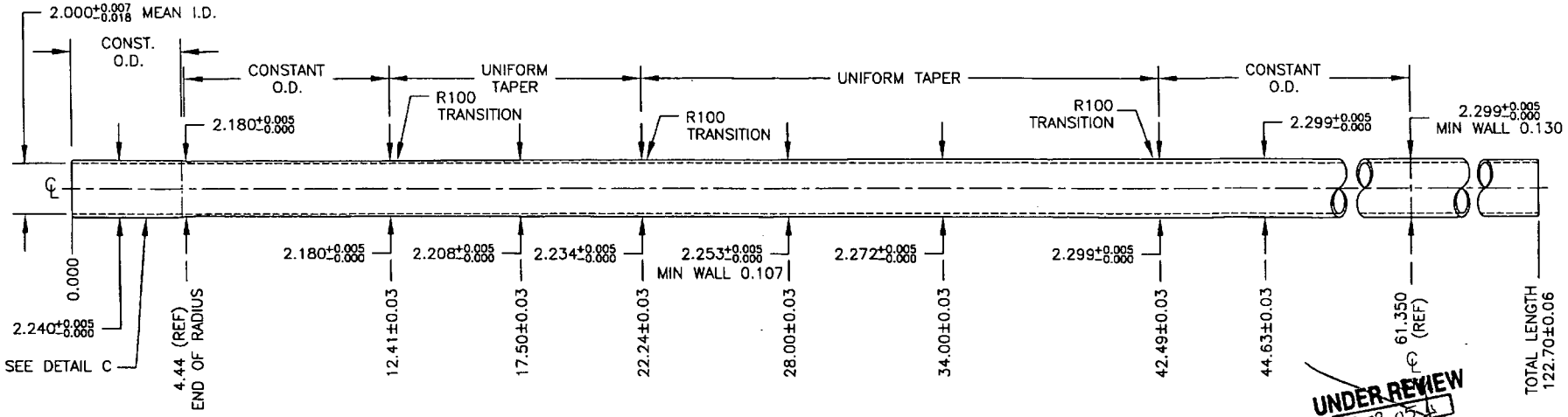
RELEASED
06.10.31

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WITHOUT NOTICE

WORK ORDER NO. L26033

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DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D350-748-241 REV. D
DATE 06.10.31		SHEET 2 OF 3
		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE 1:8

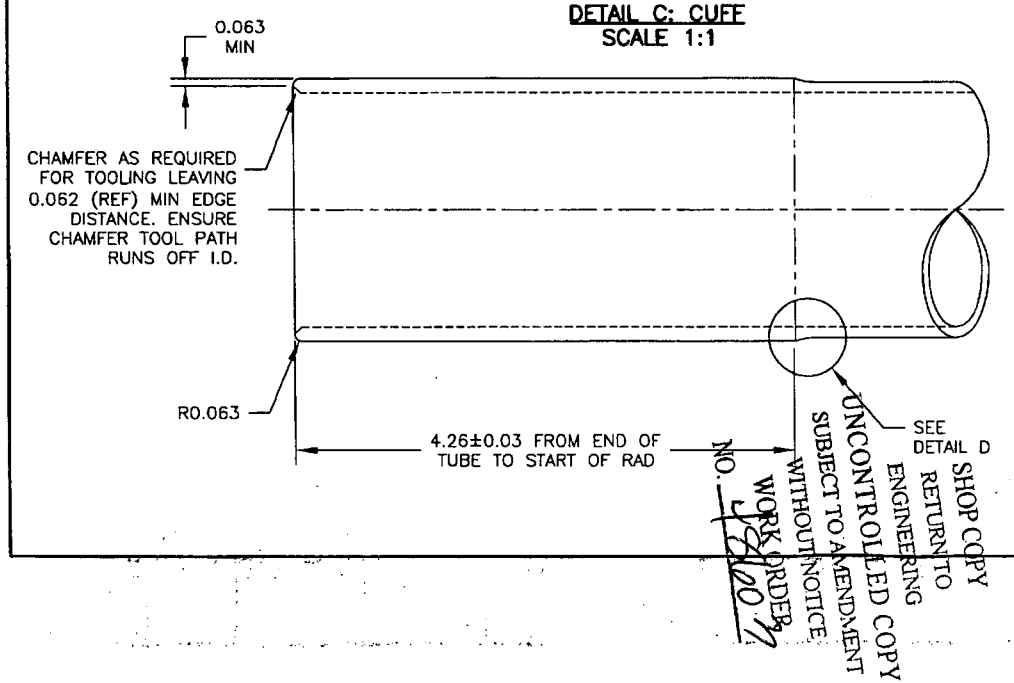


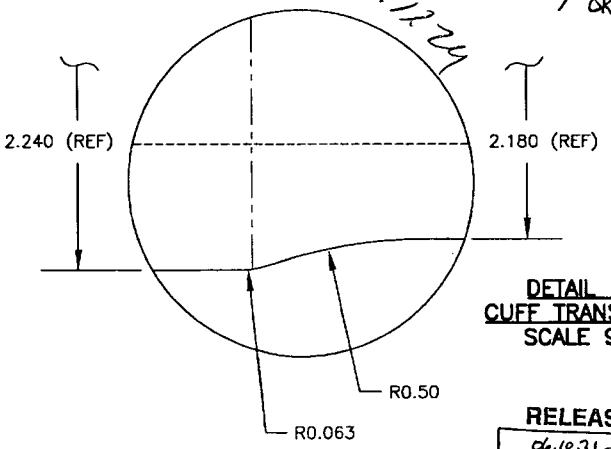
D350-748-241 MACHINING DETAIL

UNDER REVIEW
09.02.05

UNDER REVIEW
09.12.14
09.11.24
ok 09.10.22

DETAIL C: CUFF
SCALE 1:1





DETAIL D: CUFF TRANSITION
SCALE 9:1

RELEASED
06.10.31

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SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 1280

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DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D350-748-241 REV. D SHEET 3 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE 1:4

VAC AERO INTERNATIONAL INC.

RELEASE NC

GST No. : R105468102

OAK 113616

[X] HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

[] 2009 WYECROFT ROAD, UNIT B
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[] QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

11/03/20
MM / DD / YY

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

SHIP TO : DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/03/2009		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
10539		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141/241	EA	12	12	

Process Specifications: Procedure: 4353
HEAT TREATED TO 180 KSI MIN. PER DRAWING
100% HARDNESS CHECKED AS PER ASTM E-18
40/45 HRC
MATERIAL: 4130

4 PIECES B48603, B48604, B48605, B48606, P/N D350-748-241
8 PIECES B50262, B50627, B50628, B50629, P/N D350-748-141
B50621, B50622, B50623, B50625

100% HARDNESS TESTE
1-4 pcs.
42/43 HRC

V.A.I.O. TH. 25 Q.C.

GE. 11. 23

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

V.A.I.O. TH. 25 Q.C.

Authorized Q.C. Inspector

MTI METAL TREATING INSTITUTE

INTERTEK AS9100 • ISO 9001

Accred Nadca Heat Treating • W